



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3810
Job Sheet 203274



Part No: 646.3810

Job Qty: 20 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/12/19

Type: Stock

Description:

Note: DWG 646.3800 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD IPP REV:B 18.07.03 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Conventional Mill - 1	20 pcs		12/12/19	0.00	6.56	Conventional Mill - 1		19/11/22
							Conventional Mill - 2		
120	QC 2	20 pcs		12/12/19	0.00	0.00	QC 2 - 1		19/11/22
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S233924



Part: 646.3810

Job No: 203274

Serial No/Batch: S233924

Revision: Rev A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/22/19

0,438, 1,318, 2,148, 3,078

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130 QC 8	20 pcs	12/12/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Outsource - 4 - Anodize	20 pcs	12/12/19		ATG001-VC	10
150 Packaging 2-1 - Receive - B4B	20 pcs	12/12/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 -	

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19/11/23

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				B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
155 QC 6	20 pcs	12/12/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	DEC 13 2019 63
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	20 pcs	12/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
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					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DEC 1 6 2019
					Packaging 3 - 36 - B4B	<i>DP</i>
190 QC 21 - SA	20 pcs	12/12/19	0.00 0.00		QC 21 - SA - 21	<i>21</i>
					QC 21 - SA - 70	<i>21</i> DEC 1 6 2019
					QC 21 - SA - 53	

Part Op 110 - (Manufacture as per dwg) 1-Machine per DWG
Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check) *#45230*
140 - Issue P/O to ATG: *203274* AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required
150 - (Receive & Inspect for Damage & Mat'l Certs)
155 - (QC6- All purchased or subcontracted products)
180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6A1.00X0.75X0.125X0.060	7075T6 Angle 1.0" X .75" X .125" X .060"W	6 ft (.3 ea)	110-Conventional Mill - 1	<i>FM137084</i>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Conventional Mill - 1	M7075T6A1.00X0.75X0.125X0.060	6	24	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	1.000Inches ± 0.010	1.010 0.990	1.003	
2	Bracket	0.130Inches ± 0.010	0.140 0.120	0.125	
3	Bracket	0.060Inches ± 0.010	0.070 0.050	0.062	
4	Bracket	0.750Inches ± 0.010	0.760 0.740	0.753	
5	Bracket	0.090Inches ± 0.010	0.100 0.080	0.089	
6	Bracket	0.060Inches ± 0.010	0.070 0.050	0.060	
7	Bracket	3.500Inches ± 0.010	3.510 3.490	3.502	
8	Bracket	0.440Inches ± 0.010	0.450 0.430	0.438	
9	Bracket	0.880Inches ± 0.010	0.890 0.870	0.880	
10	Bracket	0.880Inches ± 0.010	0.890 0.870	0.880	
11	Bracket	0.880Inches ± 0.010	0.890 0.870	0.880	
12	Bracket	0.380Inches ± 0.010	0.390 0.370	0.380	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



NCR No.		Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)	
Date :		Sequence #:		QTY Affected :		Disposition		Completed By	
Description Work Order Deviation								Lead hand / Supervisor	
								QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045230



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045230

PO Date: 11/27/19

Due Date: 12/13/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

2019-12-05

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203274	646.3810	646.3800 Rev A	Bracket : Various STC's Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/6/19	20 pcs	0 pcs	20 pcs	\$7.72/pcs	\$154.40
Line Item Note: Need by Dec 6												
2	203276	646.3813	646.3800 Rev A	AS350 Strut Bracket : Various STC's Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/13/19	20 pcs	0 pcs	20 pcs	\$7.27/pcs	\$145.40



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K6A 1K7
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PURCHASE ORDER POHB045230



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	202758	D5589-2	D5589 Rev B	Gusset, Outboard RH : Various STC's Issue P/O: _____ 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5589 2- Prime Grey as per Dwg. QSI005 4.2.1.3.2 Certification of Conformity is required.	Firmed	X8	12/13/19	8 pcs	0 pcs	8 pcs	\$7.27/pcs	\$58.16
4	203255	647.2011	647.2000 Rev N/C	Lower Strut : Various STC's Issue P/O: _____ ANODIZE AS PER DWG Finish: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOUR BLACK PRIME IAW MIL-P-23377J TYPE I CLASS N	Firmed	X4	12/6/19	4 pcs	0 pcs	4 pcs	\$14.57/pcs	\$58.28
Line Item Note: Need by Dec 6												
5	200191	D5580-1	D5580 Rev A	Shim, Cable Cutter : Various STC's Issue P/O: _____ 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5580 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	X12	12/2/19	12 pcs	0 pcs	12 pcs	\$7.02/pcs	\$84.24
Line Item Note: ***RUSH*** Need by Dec 2nd												
6	203272	646.3716	646.3700 Rev A	Gauge Bracket : Various STC's Issue P/O to ATG : _____ As per drawing 646.3700 RevA: - Hard Anodize MIL-A-8625 Type III, Class 2, Colour Black - Cardinal 4860-50 Pretreatment Prime - Prime IAW MIL-P-23377 J Type I Class N	Firmed	X25	12/13/19	25 pcs	0 pcs	25 pcs	\$7.32/pcs	\$183.00
7	202884	647.4114	647.4100 Rev N/C	Shim : Various STC's Issue P/O _____ ATG, black anodize and prime as per dwg 647.4114 Rev. N/C	Firmed	X18	12/13/19	18 pcs	0 pcs	18 pcs	\$7.42/pcs	\$133.56
Grand Total:												\$817.04

Guerin

	Dart Aerospace Ltd. 1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada Tel (613) 632-5200	PURCHASE ORDER POHB045230 
Order Notes Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.		

Plex 12/5/19 8:51 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919190

Date: 10-Dec-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 5195271 Job: 26524 PO: POHB045230		Rev: A Expiry Date: 10/31/2020 Line: 1
20 ea	Part: 646.3813 AS350 Strut Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5195271 Job: 26525 PO: POHB045230		Rev: A Expiry Date: 10/31/2020 Line: 2
4 ea	Part: 647.2011 Lower Strut Hard Anodize per MIL-A-8625F, Type III, Class2, Black, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6-.9 mils) per drawing Batch/Lot#: 5195271 Job: 26527 PO: POHB045230		Rev: NC Expiry Date: 10/31/2020 Line: 4
Made in Canada.			

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919190

Date: 10-Dec-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
25 ea	Part: 646.3716 Rev: A Gauge Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5195271 Expiry Date: 10/31/2020 Job: 26529 Line: 6 PO: POHB045230		
18 ea	Part: 647.4114 Rev: N/C Shim Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5195271 Expiry Date: 10/31/2020 Job: 26530 Line: 7 PO: POHB045230	RECEIVED DEC 11 2019 DART AEROSPACE LTD.	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: DEC 10 2019 Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 919190 Date: 10-Dec-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053 Ph: 613 632-9577 Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	Made in Canada.	